



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18635-1
Job Sheet 175517



Part No: RBT18635-1

Job Qty: 10 ea

Part Name: Adapter Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18635 Rev 2A IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/12/18	0.00	0.00	Start Up Machining-4		18/5/14
120	Lathe Conv	10 pcs		4/12/18	0.50	1.25	Lathe Conv-2		
130	QC	10 pcs		4/12/18	0.00	0.00	QC2 Machining-5		
140	Mill Conv	10 pcs		4/13/18	0.25	0.83	Mill Conv 2		
150	QC	10 pcs		4/13/18	0.00	0.00	QC2 Machining-5		18/5/15
160	QC	10 pcs		4/13/18	0.00	0.00	QC8 Machining-5		18/5/15
170	Outsource	10 pcs		4/13/18	0.00	0.00	Outsource12		18/5/15
180	Packaging	10 pcs		4/13/18	0.00	0.00	Packaging2		18/5/15
190	QC	10 pcs		4/13/18	0.00	0.00	QC6		18/5/15
200	Packaging	10 pcs		4/13/18	0.00	0.00	Packaging3-2		18/5/15
210	QC21-SA	10 Ea		4/13/18	0.00	0.00	QC21		18/5/15

Part Op 120 - Machine as per DWG

Descriptions: 140 - Drill and tap hole as per DWG.

170 - Issue P/O to Groupe Altech; PO 039918 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required

180 - Receive

200 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.625	1144 Steel Proof Round Bar 0.625"	.7500 ft (.075 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R0.625	1	10	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

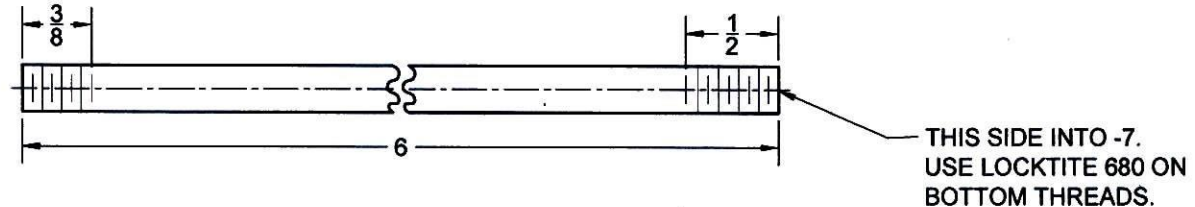
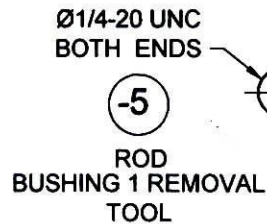
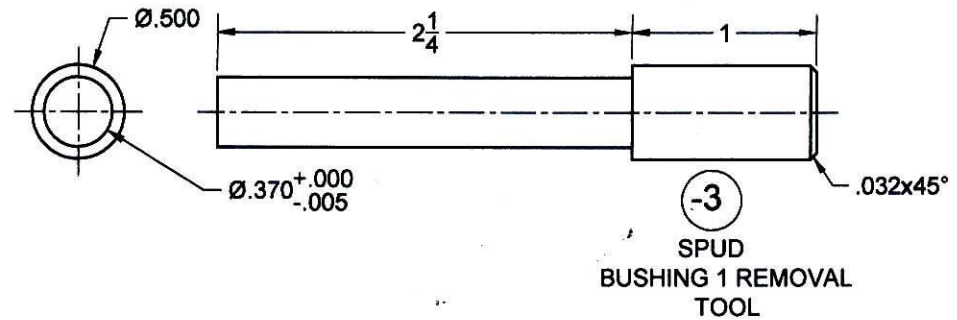
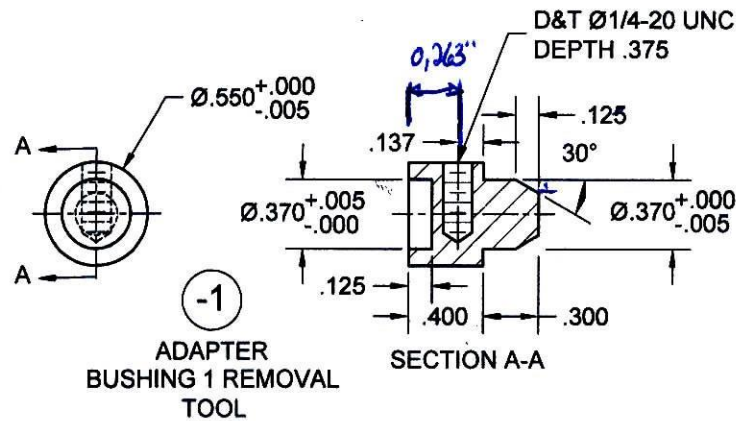
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Dis				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
								Date: 05/14/18	

Root Cause				FAULT CATEGORIES				Container No: S070958 Part: RBT18635 - 1 Job No: 175517 Serial No/Batch: S070958 Revision: 2A Inspector:			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐				
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Outside Dimensions	☐		
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Over/Under tolerance	☐		
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Part Incorrect	☐		
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Part Lost/Missing	☐		
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Part Moved	☐		
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Drawing	☐		
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Finish	☐		
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Misread	☐		
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Turning Sequence	☐		
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED .125 x 30° TO -1 ADAPTER.	1/15/07		
2	CHANGED -11 R.D63 TO CHAMFER & -7 MAT. FROM 1018.	1/13/07		
2A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, CH'D ENGRAVE NOTE -7 & -11.	1/21/10	RJC	RW



ASSY QTY	ASSY QTY	B/O	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	ADAPTER BUSHING 1 REMOVAL TOOL	STRESS PROOF	Ø9/16 x 3/4	1
			-3	1	SPUD BUSHING 1 REMOVAL TOOL	STRESS PROOF	Ø1/2 x 3-3/8	1
			-5	1	ROD BUSHING 1 REMOVAL TOOL	1018	Ø1/4 x 6-1/8	1
			-7	1	HANDLE BUSHING 1 REMOVAL TOOL	STRESS PROOF	Ø3/4 x 3-1/8	2
			-9	1	SPUD BUSHING 2 REMOVAL TOOL	STRESS PROOF	Ø9/16 x 3-1/8	2
			-11	1	BUSHING RECEIVER	6061	Ø1-1/4 x 3-1/8	2
ASSY #								

RED BARN MACHINE	
TITLE T/R BLADE BUSHING REMOVAL TOOL	
DWG NO. RBT18635	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-16-06
SHEET 1 of 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039918**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039918
PO Date: 5/16/18
Due Date: 5/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pytm Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	175517	RBT18635-1	Adapter Bushing -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/18/18	5 pcs	0 pcs	5 pcs	\$12.00/pcs	\$60.00
2	175520	RBT18635-3	Spud -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/18/18	5 pcs	0 pcs	5 pcs	\$12.00/pcs	\$60.00

Grand Total: \$120.00

Order Notes

CZ

DAS
11
9-89



Certificat de Conformité / Certificate of Compliance

(009382-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009382 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
17-May-2018		Aman		PO039918				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18635-1 Rev.	RBT18635-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	5	5	0	0	AS ⁰ 11 -89
2	RBT18635-3 Rev.	RBT18635-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.